

Work Order ID 63566

Thursday, November 04, 2010 11:06:27 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 11/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

R

Date:

10-11-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3914	B

100 Weld per dwg A/R S.S. rod Batch: *111585* 0.00
Large Fab

Large Fab Memo 0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

Cpl 10-10-09

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo 0.00

Quality Control

*J.B.E
10-11-09*

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

*** mask sides of hinge prior to powdercoat***

Start Time:

Oven Temperature:

Finish Time:

140

Wing Walk as per dwg QSI005 4.4 Batch M115790

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

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Required Date: 11/12/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 10/11/12 @

160

Identify as per dwg & Stock Location: G-A

0.00



Packaging

Memo

0.00

Packaging

w/o 63564

EP 10/11/12 @

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/15
MF
10-11-12

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Picklist Print

Thursday, November 04, 2010 11:06:31 AM

Page 1

Work Order ID: 63566

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)



Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	23.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>23</div> <div></div> </div>													
<div> <div>60470</div> <div>3</div> <div></div> </div>													
<div> <div>61953</div> <div>20</div> <div></div> </div>													
D3914-1 Rib		Manufactured	No			100	Each	4.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>4</div> <div></div> </div>													
<div> <div>60703</div> <div>4</div> <div></div> </div>													
D3914-7 Rib		Manufactured	No			100	Each	4.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>4</div> <div></div> </div>													
<div> <div>60676</div> <div>4</div> <div></div> </div>													
D4016-3 Hinge Half, Lid		Manufactured	No			100	Each	7.0000	3	3			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST116</div> <div>6</div> <div></div> </div>													
<div> <div>60723</div> <div>6</div> <div></div> </div>													
<div> <div>WA</div> <div>1</div> <div></div> </div>													
<div> <div>60548</div> <div>1</div> <div></div> </div>													

Pl 10.14.09

(2)

Pl 10.10.09

(2)

Pl 10.14.09

2

Pl 10.14.09

(3) (2)

(1)

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Picklist Print

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Page 2

Work Order ID: 63566

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 1.00

Required Qty: 1.00

D4018-5



Rib

Manufactured No

100 Each

15.0000

9

9

Location

Loc Qty

Loc Code

WA

15

59929

15

100 Each

3.0000

1

1

Location

Loc Qty

Loc Code

WA

3

60643

1

60733

2

100 Each

4.0000

1

1

Location

Loc Qty

Loc Code

WA

4

56050

1

59987

1

60734

2

100 Each

3.0000

1

1

Location

Loc Qty

Loc Code

WA

3

60546

1

61066

2

D4021-3



Data Plate

Manufactured No

D4035-041



Lid Rib Assembly, Fwd (350 Basket)

Manufactured No

Thursday, November 04, 2010 11:06:31 AM

Shop Packet Print

Page 2

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Picklist Print

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Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 1.00

Required Qty: 1.00

D4035-043

Manufactured No

100

Each

3.0000

1

1



Lid Rib Assembly, Aft (350 Basket)



Pl 10-14-09

Location

Loc Qty

Loc Code

WA

3

60475

1

61067

2

(1)

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label



M115050

x1 10/14/10

W/O:		WORK ORDER CHANGES					
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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3P 1-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63545

P10-11-04

RELEASED
10.08.05
ECN 10-596

B	REMOVED D4096-210, UPDATED DETAIL F ACCORDINGLY (A3-2) REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>SC</i>		
CHECKED	<i>SC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>SC</i>	D3914	SHEET 1 OF 4
APPROVED	<i>SC</i>	TITLE	SCALE
DE APPR.	<i>SC</i>	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

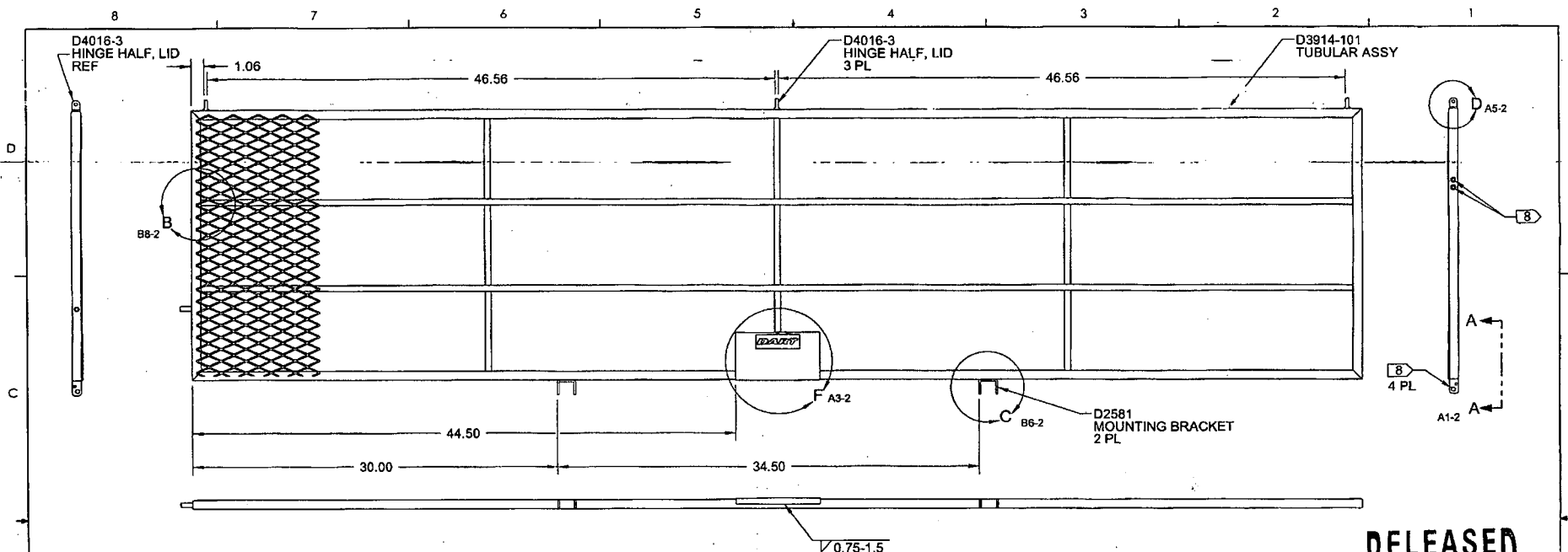
W/O:		WORK ORDER CHANGES					
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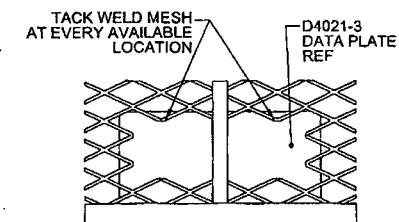
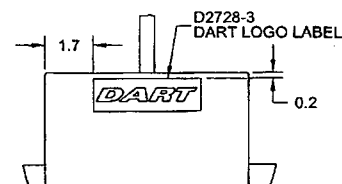
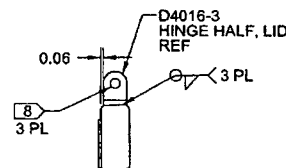
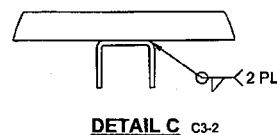
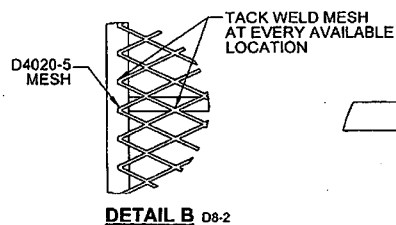
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D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	A.5	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	WJ	D3914	SHEET 2 OF 4
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
10.08.12 UP

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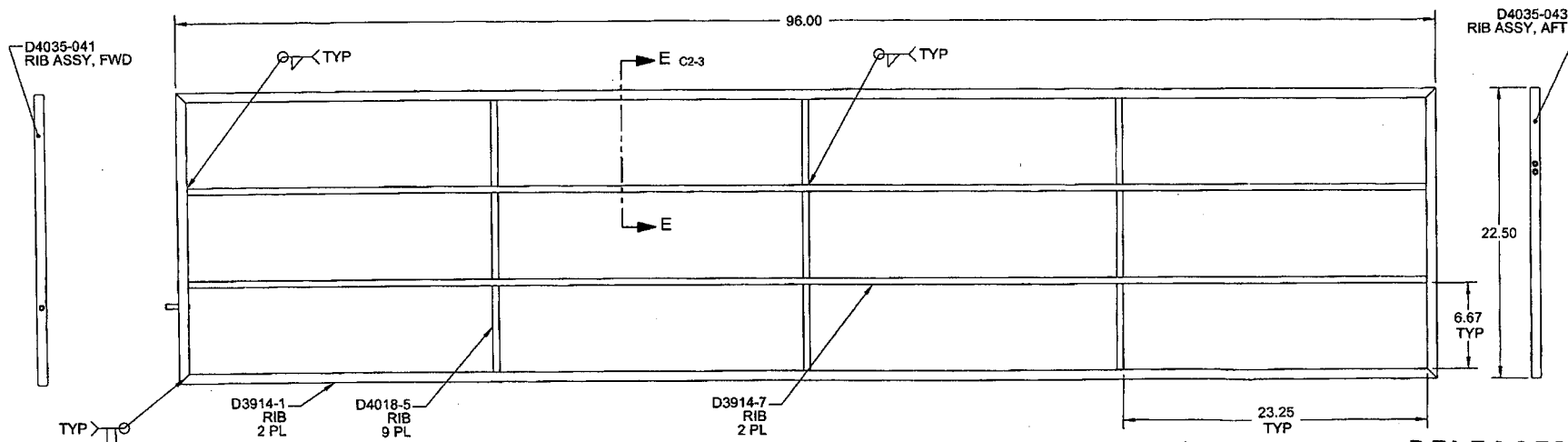
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E CS-3



(B) D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	R	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	MP	D3914	SHEET 3 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	LONG BASKET LID ASSY (350)	NTS
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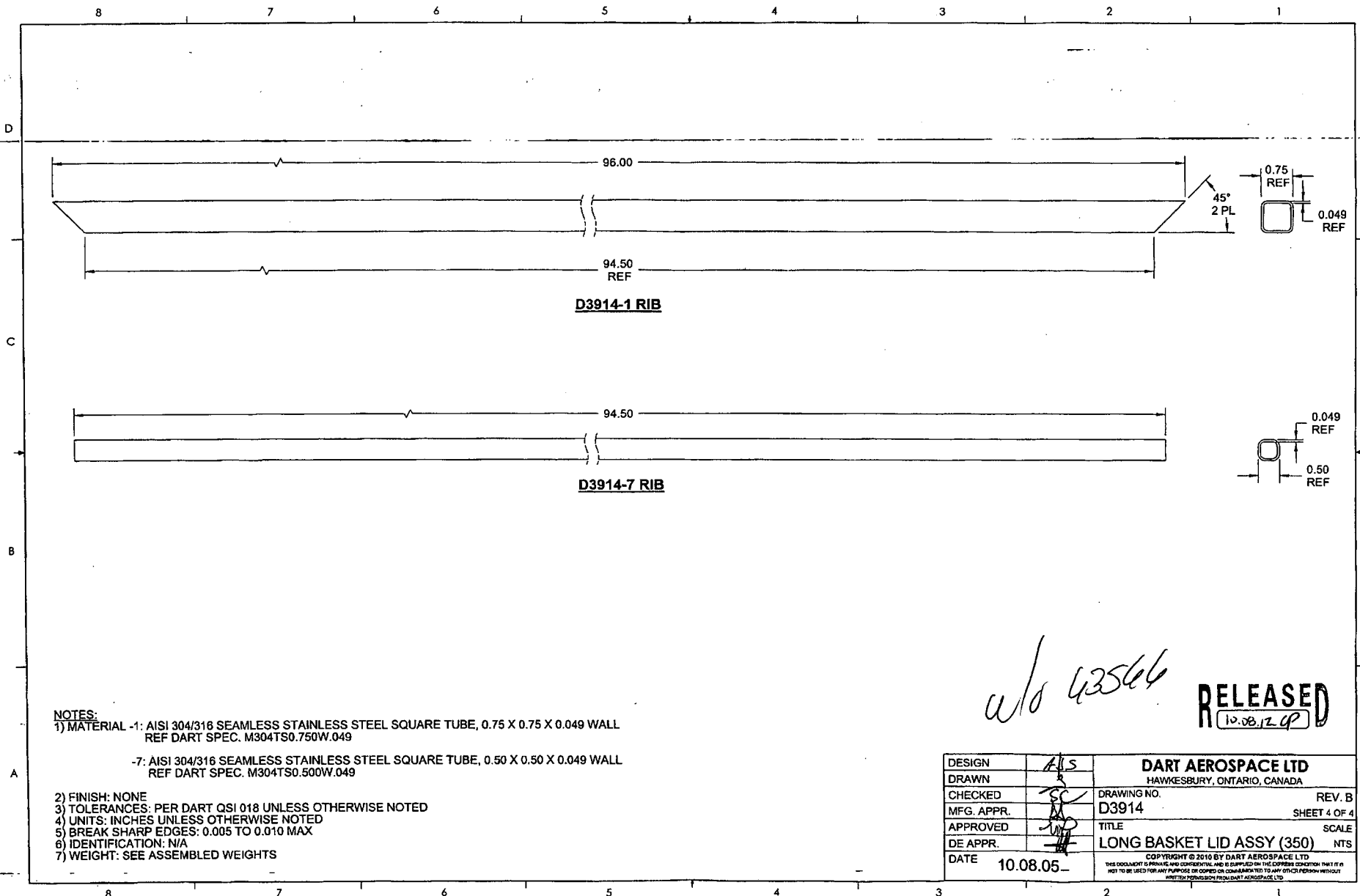
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NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED	SC	D3914	SHEET 4 OF 4
MFG. APPR.	SC	TITLE	SCALE
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DATE	10.08.05		

W/O 43566

RELEASED
10.08.12 GP

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